

Date: Wednesday, 04/06/2008 8:31:02 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	TURNING DETAIL FOR D2940-1	
Job Number :	39686	Part Number :	DSK081	
Estimate Number :	13237	Drawing Number :	DSK081 REV A B E 08.06.04	
P.O. Number :		Project Number :	N/A	
This Issue :	04/06/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	A	
First Issue :	/ /	Type :	MACHINED PARTS	
Previous Run :	38134	Material :		
Written By :		Due Date :	27/06/2008	Qty: 10 Um: Each
Checked & Approved By :	JLD 08.6.04			
Comment :	est rev A. 08.03.13 new issue EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D6104007	Round Billet, 17.4
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Billet

BATCH: 39627

20 08/07/23

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

Turn blank as per Folio FA079

20 08/07/23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/07/23 (10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

20 08/07/26 (10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location: ENC

20 08/07/26 (10)

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/08/01

Job Completion



MF 08-07-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39686
Description: Turning Detail for D2940-1		Part Number: DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.216	3.216	3.216	3.216	3.216
B	4.946	4.966		4.950	4.955	4.955	4.955	4.955
C	0.718	0.738		.725	.725	.728	.728	.728
D	0.090	0.110		.101	.101	.100	.100	.100
E	3.564	3.584		3.574	3.574	3.574	3.574	3.575
F	0.022	0.042		.032	.032	.032	.032	.032
G	3.444	3.464		3.454	3.454	3.454	3.454	3.454
H	0.112	0.132		.122	.122	.122	.122	.122
I	2.170	2.190		2.180	2.180	2.180	2.180	2.180
J	4.451	4.471		4.461	4.461	4.461	4.461	4.461
K	0.413	0.433		.423	.423	.423	.423	.423
L	0.913	0.933		.923	.923	.923	.923	.923
M								
N								
O								
P								

Measured by: *RP* Date: 08/07/26

Audited by: *LS* Date: 08/01/26

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081		Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

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Lathe Section								
A	3.211	3.216		3.216	3.216	3.216	3.216	3.216
B	4.946	4.966		4.956	4.956	4.956	4.956	4.956
C	0.718	0.738		.727	.727	.728	.728	.728
D	0.090	0.110		.100	.100	.100	.100	.100
E	3.564	3.584		3.574	3.574	3.574	3.574	3.574
F	0.022	0.042		.032	.032	.032	.032	.032
G	3.444	3.464		3.454	3.454	3.454	3.454	3.454
H	0.112	0.132		.122	.122	.122	.122	.122
I	2.170	2.190		2.180	2.180	2.180	2.180	2.180
J	4.451	4.471		4.461	4.461	4.461	4.461	4.461
K	0.413	0.433		.423	.423	.423	.423	.423
L	0.913	0.933		.923	.923	.923	.923	.923
M								
N								
O								
P								

Measured by:	<i>[Signature]</i>	Date:	08/07/26
Audited by:	<i>[Signature]</i>	Date:	08/07/26
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

Dart Aerospace Ltd

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